

Work Order ID 83546

83546

Page 1

April-19-12 11:20:35 AM

Item ID: D3811-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Track
 Start Date: 19/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3811	Rev A								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blank 23.250 " long

12-04-24 (24)

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA776 Rev: 1A & Dwg D3811 Rev: A 2-Deburr per dwg D3808

12/04/22 4

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

12/04/22 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83546

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 19/04/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 03/05/2012 **Req'd Qty:** 4.00

4

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

Memo

0.00

HandFinish

Hand Finishing

165.

QC7.

170

Identify as per dwg & Stock Location 262

0.00

170

Memo

0.00

Packaging

Packaging

4ϕ $\$1352$
 4ϕ $\$12/5/02$
 (40) $12/5/38$

180

QC21- Final Inspection - Work Order Release

0.00

180

Memo

0.00

QC

Quality Control

12/5/79

MCS 12/05/03

Dart Aerospace Ltd

W/O: 83546		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-5-2		ADD (SEQUENCE) FOR QCL7. 165 PERMANENT CHANGE.	RL				

Part No: D3811-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:20:38 AM

Page 1

Work Order ID: 83546

83546

Parent Item: D3811-1

D3811-1

Parent Item Name: Seat Track

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	70.9900	2	8.421053			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

**

12-04-24

Location

Loc Qty

Loc Code

MAT004

70.99

103069

12

107387

22.99

16742

36

7.75

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83546
Description: Seat Track		Part Number: D3811-1
Inspection Dwg: D3811	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.40	+/-0.030	.403	✓		SLO8	Vern
6.70	+/-0.030	6.700	✓		SD 03	
0.700	+/-0.010	.700	✓		SLO8	Vern
1.400	+/-0.010	1.401	✓			
0.990	+/-0.010	.993	✓			
Ø0.281 x 0.44 deep	+0.006/-0.001 x +/-0.030	Ø.283 x .442	✓			
0.780	+/-0.010	.780	✓			
6.48	+/-0.030	6.480	✓		SD03	Vern 10"
Ø0.196	+0.005/-0.001	Ø.198	✓		SLO8	Vern
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø.388 x 100	✓		SLO8	
R0.13	+/-0.030	R.130	✓		Rad Gauge	
0.70	+/-0.030	.700	✓		SLO8	
6.44	+/-0.030	6.440	✓		SD03	
R1.00	+/-0.030	R.1.000	✓		Rad Gauge	
1.576	+/-0.010	1.576	✓		SLO8	
1.76	+/-0.030	1.770	✓		SLO8	Vern
10.00	+/-0.030	9.9995	✓		SD03	Vern 10"
0.590 pitch	+/-0.010	.590	✓		SLO8	Vern
0.788 pitch	+/-0.010	.788	✓		SLO8	
23.00	+/-0.030	23.000	✓		Tape	
Ø0.323	+0.006/-0.001	0.323 0.323	✓		RA26	Vern
0.27	+/-0.030	.270	✓		RA26	Vern
1.08	+/-0.030	1.081	✓		RA26	Vern
20.68	+/-0.030	20.68	✓		RA-21	TAPE
0.44	+/-0.030	.442	✓		SLO8	Vern
1.24	+/-0.030	1.242	✓		RA26	Vern
0.286 x 60°	+/-0.010 x 0.5°	.285 x 60°	✓			
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø.386 x 100°	✓			
R0.032	+/-0.010	R.032	✓		Rad Gauge	
0.132	+/-0.010	.133	✓		SLO8	Vern
0.315	+/-0.010	.315	✓			
0.015 x 30°	+/-0.010 x 0.5°	.015 x 30°	✓			
0.100	+0.030/-0.010	.110	✓			
1.98	+/-0.030	1.981	✓			

DART AEROSPACE LTD		Work Order:	83546
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+/-0.010	0.122	✓		SLO8	VEN
0.730	+/-0.010	0.730	✓		↓	
0.195	+/-0.010	0.194	✓		↓	
0.630	+/-0.010	0.631	✓		↓	

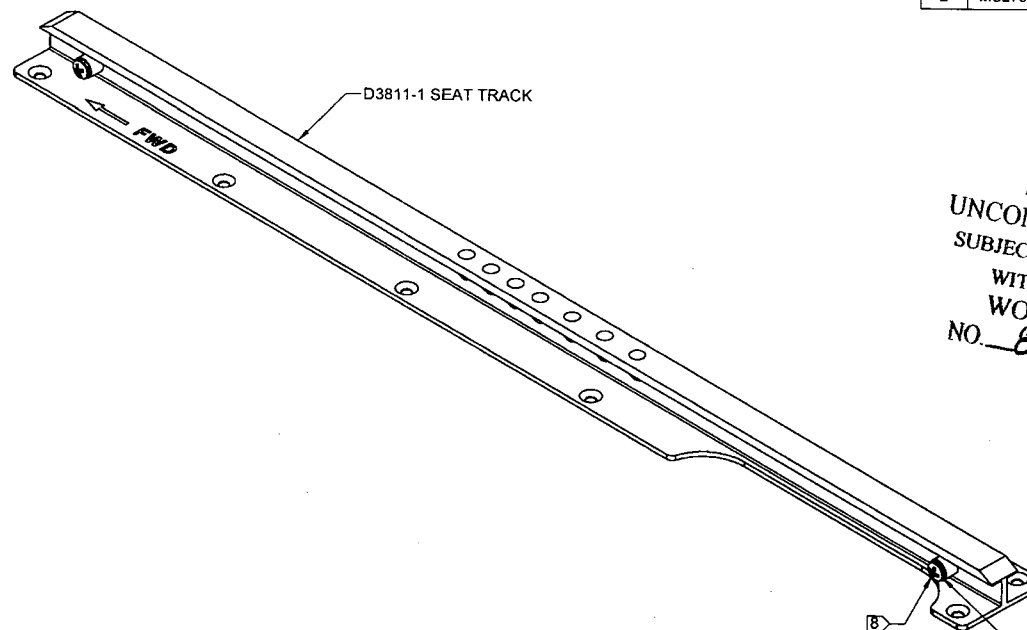
Measured by:	SJA
Date:	12/04/27 12-4-30

Audited by:	B.A
Date:	12/05/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	MA

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



D3811-041 SEAT TRACK ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83546 MLJ
12/04/19

RELEASED
03-09-2019

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

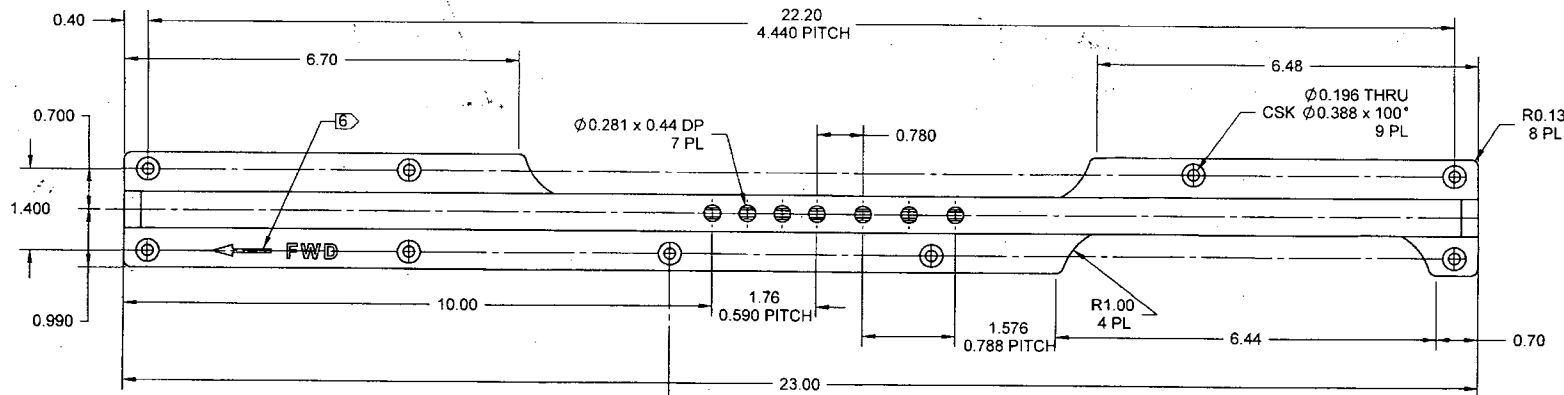
A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

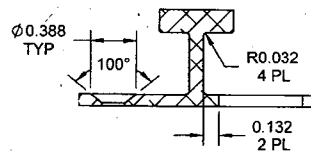
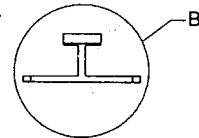
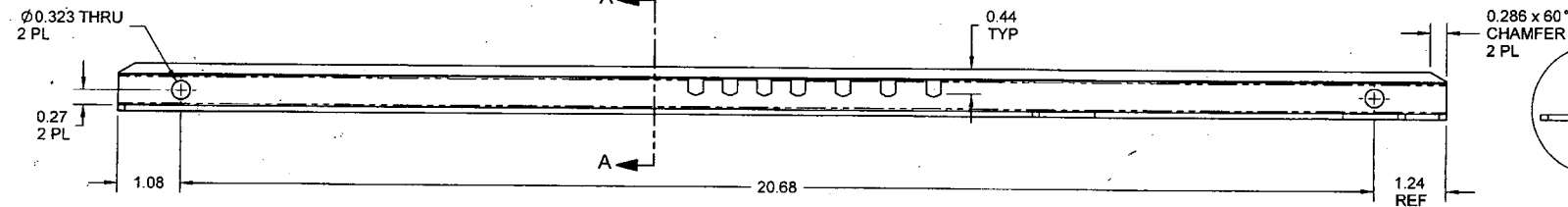
DRAWING NO. **D3811** REV. A
SHEET 1 OF 3
TITLE **SEAT TRACK ASSEMBLY** SCALE NTS

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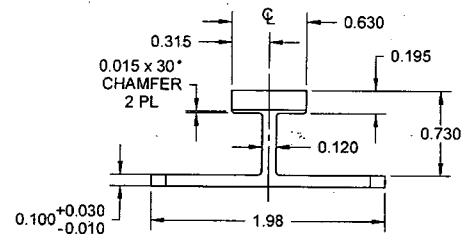
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83546



SECTION A-A



DETAIL B

D3811-1 SEAT TRACK

RELEASED
06.09.30 1/14

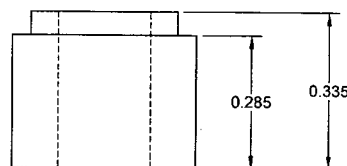
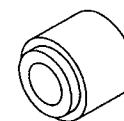
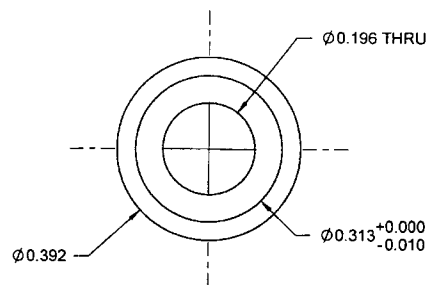
NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.25 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.724 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

83546



D3811-3 BUSHING

RELEASED
08-09-30-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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